

Work Order ID 82566 -2

April-03-12 8:35:20 AM

82566

AAH

Page 1

Item ID: D2563

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 03/04/2012 Start Qty: 4.00

Required Date: 17/04/2012 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

QC:

Date: 12/04/03

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Nbr

Revision Nbr

D2563

Rev C

100

100

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4-Grind

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

4

12.05.02

12.05.02

12.05.04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82566

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Item ID: D2563

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment Assembly

Start Date: 03/04/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

5/12/12

(4)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

(4)

12-5-7

Hand Finishing

140

QC3- Inspect Part finish

0.00

140

QC

Memo

0.00

1

12-05-09

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D2563

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment Assembly

Start Date: 03/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Weld per dwg A/R Aluminum rod Batch: 119785

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

3

0

12.05.09

12.05.09

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

8/15/10

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

8/15/10

(+3)

W/O:		WORK ORDER CHANGES					
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Item Name: Step Weldment Assembly

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Start Date: 03/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

175

Pressure Wash per QSI005 4.3

0.00

175

HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

3X ✓

Mk
12/5/10

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

3X ✓

Mk
12/5/10

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-50
320 °F
11-20

Wing Walk as per dwg QSI005 4.4 Batch

0.00

190

190

HandFinish

Memo

0.00

Hand Finishing

3 ✓

12-5-10

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

PP 82565

3x 4

12/12/10

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

↓

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/5/17

mf

12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-03-12 8:35:24 AM

Page 1

Work Order ID: 82566

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

82566
D2563

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured No

100

Each

95.5000

1

4

**

Re 12.04.23

D2244-116

Step Extrusion

Location

Loc Qty

Loc Code

HALL

2.5

60307

2.5

WA

93

80803

93

100

Each

38.0000

2

8

**

12.05.01

D2561

Manufactured No

D2561

Lug

Location

Loc Qty

Loc Code

WA

24

80813

24

WA015

14

66813

5

74534

9

100

Each

16.0000

2

8

**

12.05.01

D2564

Manufactured No

D2564

Mounting Angle

Location

Loc Qty

Loc Code

WA018

B83712

16

71591

16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-03-12 8:35:24 AM

Page 2

Work Order ID: 82566

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

82566

D2563

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

100

Each

50.0000

1

4

D2673-34

End Plate

**

12.05.01

Location

Loc Qty

Loc Code

WA

30

81468

30

WA015

20

59690

20

4

D2673-34

Manufactured No

150

Each

50.0000

1

4

D2673-34

End Plate

**

12.05.02

Location

Loc Qty

Loc Code

WA

30

81468

30

WA015

20

59690

20

4

April-03-12 8:35:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

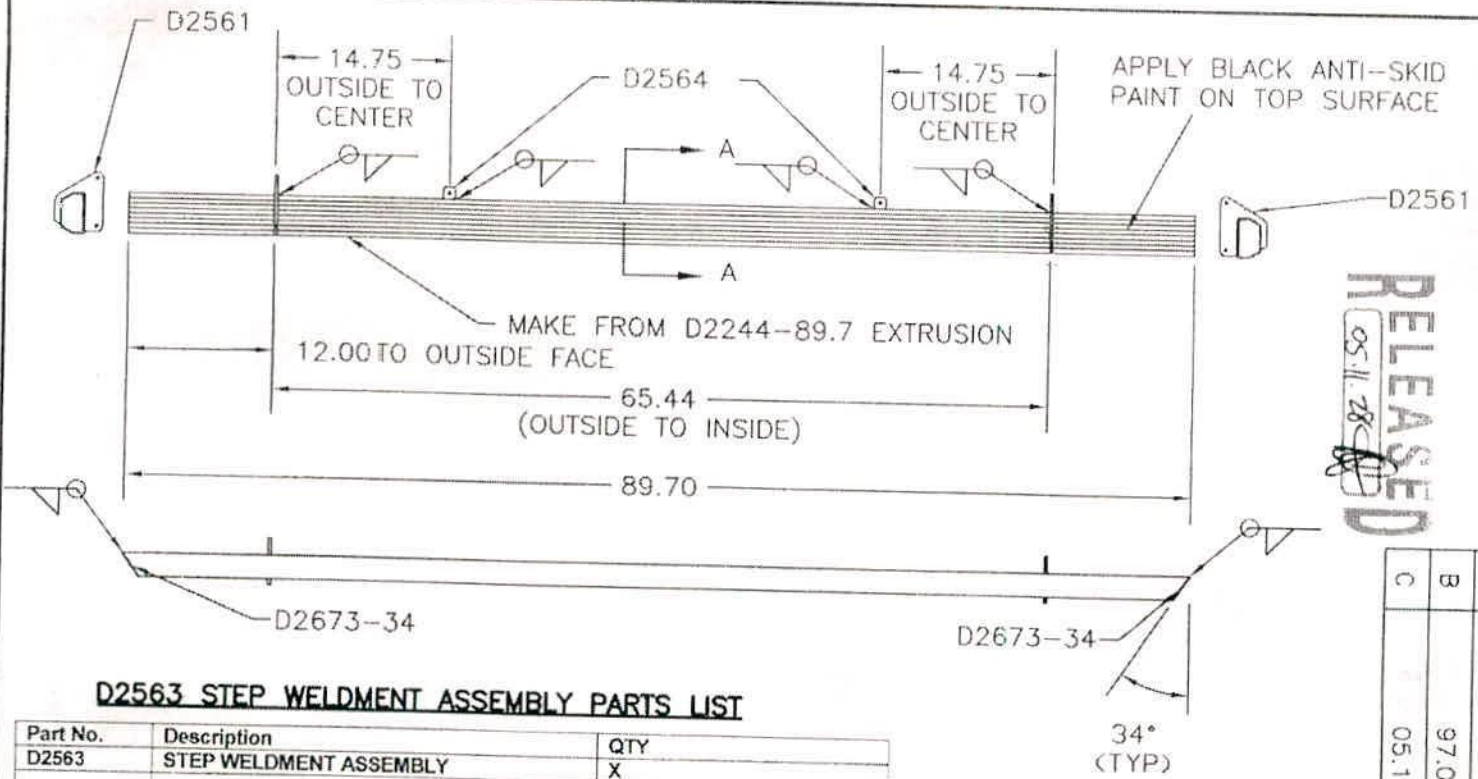
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
05.11.28

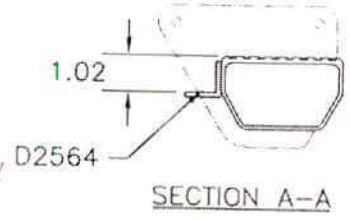


D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82566 MLS
12/04/03



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	Pt	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2563	
DATE		TITLE	SHEET 1 OF 1
05.11.14		STEP WELDMENT ASSEMBLY	SCALE
			1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

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